



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE1X56-122-294
Job Sheet 188113



Part No: RBE1X56-122-294

Job Qty: 2 pcs *5 MLC*

Part Name: Push-Out Device



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/3/19

Job Tracking No:

Due Date: *3/18/19*

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE1X56-122-294 Rev.1 IPP Rev. A 18.12.20 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	3/18/19		0.00	0.40	Small Fab - 1		
							Small Fab - 2		<i>MLC</i>
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	3/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
120	Packaging 3-1 - Stock - B4B	2 pcs	3/18/19		0.00	0.00	QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		



Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S165290



Part: RBE1X56-122-294

Job No: 188113

Serial No/Batch: S165290

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 03/22/19

DAS
40
9-89
MAR 22 2019

DAS
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9-89

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	DAS
130 QC 21 - FG	2 pcs	3/18/19	0.00 0.00	QC 21 - FG - 21	21 MAR 26 2019

Part Op
Descriptions: 100 - Assemble as per DWG.

Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
8297T169	Small O-Ring, Dash # 110	2 (1 ea)	100-Small Fab - 1	5144270	
8297T174	Large O-Ring, Dash # 115	2 (1 ea)	100-Small Fab - 1	5144272	
RBE1X56-122-294-1	Outside Rod	2 pcs (1 ea)	100-Small Fab - 1	5155926	
RBE1X56-122-294-3	Plug	2 pcs (1 ea)	100-Small Fab - 1	5157087	
RBE1X56-122-294-5	Threaded Rod	2 pcs (1 ea)	100-Small Fab - 1	5155560	
RBE1X56-122-294-7	Piston	2 pcs (1 ea)	100-Small Fab - 1	5154501	
RBE1X56-122-294-9	Insert	2 pcs (1 ea)	100-Small Fab - 1	5156575	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	8297T169	2	0	0
	8297T174	2	0	0
	RBE1X56-122-294-1	2	0	0
	RBE1X56-122-294-3	2	0	0
	RBE1X56-122-294-5	2	0	0
	RBE1X56-122-294-7	2	0	0
	RBE1X56-122-294-9	2	0	0

Part Specifications	
Specifications could not be found.	

Plex 1/3/19 12:59 PM Dart.lajeunesse.marie

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

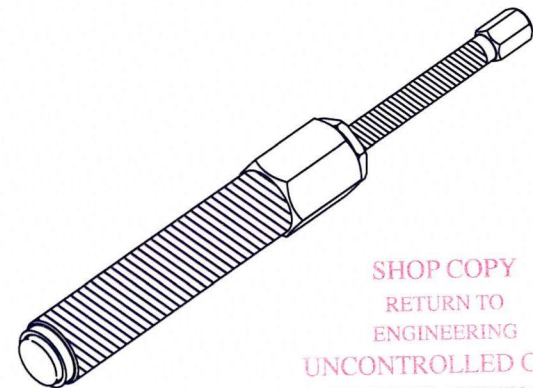
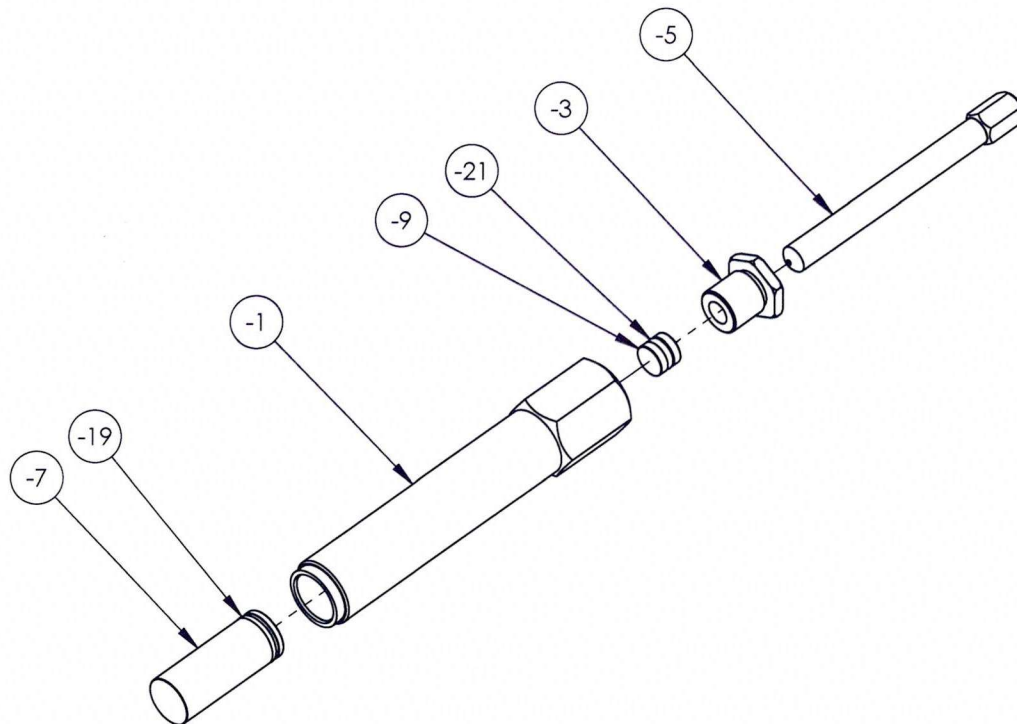
NCR No. _____

Route update only ☐

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Other/Details:					

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
1	16-0160	UPDATED TO NEW STANDARDS. -1 CH'D DIM WAS Ø.551+.005/-0.000 THRU ALL IS Ø.564/.562 THRU ALL, WAS Ø.8660/.8655 IS Ø.876/.874, WAS Ø.728 ∇ .80 M20X1.5 - 6H ∇ .70 IS M20X1.5 - 6H ∇ .80; ADDED DIM .750. -3 CH'D MATL WAS 1018 IS 1018/1020 CR. -5 CH'D MATERIAL, WAS 1018 IS 1018/1020 CR; CH'D DIM WAS M12x1.5 IS M12x1.5 - 6g; ADDED DIM SR.313. -7 CH'D MATERIAL WAS 4140 Q&T IS 303 S.S.; REMOVED FINISH; REMOVED DIM M5X0.8 - 6H ∇ .39, Ø.317, .230; CH'D DIM WAS 1.968 IS 2.22, WAS Ø.8652/.8648 IS 2X Ø.872/.871; ADDED DIM .145/.140, .25, 2X R.005, 2X R.01, Ø.698/.696. -9 CH'D MATERIAL WAS 4140 Q&T IS 303 S.S.; REMOVED FINISH; REMOVED DIM R.04; CH'D DIM WAS Ø.548+0.000/-0.005 IS 2X Ø.560/.559, WAS .275 IS .45; ADDED DIM Ø.386/.384, .145/.140, .155, 2X R.01, 2X R.005, .250, R.313.	10/11/2016	SM	JAG	



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WITHOUT NOTICE
WORK ORDER
NO. 188113 M15
19-01-01

NOTES:
1. REF. EUROCOPTER T/N: 1X56122294.
2. ALSO IN KIT RBEA62316.

DART AEROSPACE																													
TITLE PUSH-OUT DEVICE																													
DWG NO. RBE1X56-122-294	REV 1																												
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX $\pm .005$ FRACTIONS $\pm 1/8$</td> </tr> <tr> <td>SPEC</td> <td>.XX $\pm .01$ ANGLES $\pm 5^\circ$</td> </tr> <tr> <td></td> <td>.X $\pm .1$ SURFACES = 125/</td> </tr> <tr> <td>DRAWN BY: GILBERT</td> <td>1. BREAK ALL SHARP EDGES</td> </tr> <tr> <td>CHECKED: CLOUGH</td> <td>.015 x 45° OR .015R</td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> <td>2. DIMENSIONAL LIMITS APPLY</td> </tr> <tr> <td>QA APPR: LINDSAY</td> <td>AFTER PLATING</td> </tr> <tr> <td>APPROVED: GILBERT</td> <td>3. INTERPRET DIM AND TOL PER</td> </tr> <tr> <td>SCALE 1:3</td> <td>ASME Y14.5M-2009</td> </tr> <tr> <td>DATE 4/11/2012</td> <td>USED ON MODEL</td> </tr> <tr> <td></td> <td>EC135</td> </tr> <tr> <td></td> <td>SHEET 1 OF 6</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XXX $\pm .005$ FRACTIONS $\pm 1/8$	SPEC	.XX $\pm .01$ ANGLES $\pm 5^\circ$		.X $\pm .1$ SURFACES = 125/	DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES	CHECKED: CLOUGH	.015 x 45° OR .015R	OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY	QA APPR: LINDSAY	AFTER PLATING	APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER	SCALE 1:3	ASME Y14.5M-2009	DATE 4/11/2012	USED ON MODEL		EC135		SHEET 1 OF 6
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ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	OUTSIDE ROD	4140/4142		2
			-3	1	PLUG	1018/1020 CR		3
			-5	1	THREADED ROD	1018/1020 CR		4
			-7	1	LARGE PISTON	303 S.S.		5
			-9	1	SMALL PISTON	303 S.S.		6
		B/O	-19	1	LARGE O-RING	VITON	DASH # 115 (MCMaster-CARR # 8297T174)	1
		B/O	-21	1	SMALL O-RING	VITON	DASH # 110 (MCMaster-CARR # 8297T169)	1